

# Work Order ID 86357

June-27-12 3:45:15 PM

**\*86.357\***

Item ID: D2175-1

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Angle LH

Stop **\*NS2\***

Start Date: 27/06/2012 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 11/07/2012 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/06/28

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2175	Rev E

100

0.00

**\*100\***

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg.D2175

2024.063

Dwg Rev: E

Prog Rev: E

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

**\*110\***

QC

Memo

0.00

Quality Control

4 0 Jm 12-7-7

4 0 Jm 12-7-7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries



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Required Date: 11/07/2012 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC5- Inspect part completeness to step on W/O	0.00							
<b>*150*</b>									
QC	Memo	0.00							
Quality Control									
160	Chemical Conversion Coat per QSI005 4.1	0.00							
<b>*160*</b>									
HandFinish	Memo	0.00							
Hand Finishing									
170	QC7-Inspect Chemical Conversion Coat	0.00							
<b>*170*</b>									
QC	Memo	0.00							
Quality Control									

8.26710

(X9)  
-1

4 7/12 12-7-11

4 6/12 12-7-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Item Name: Angle LH

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Start Date: 27/06/2012 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 11/07/2012 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

180

Identify as per dwg & Stock Location:

0.00

**\*180\***

Packaging

Memo

GA

0.00

Packaging

*12/27/11 (4)*

190

QC21- Final Inspection - Work Order Release

0.00

**\*190\***

QC

Memo

0.00

Quality Control

*MCS 12/07/12*  
*MCS 12/07/12*

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**NOTE:** Date & initial all entries



# Picklist Print

June-27-12 3:45:20 PM

Page 1

Work Order ID: 86357

**\*86357\***

Parent Item: D2175-1

**\*D2175-1\***

Parent Item Name: Angle LH

Start Date: 27/06/2012

Required Date: 11/07/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP E04.06.09ReformatKJ/RF  
IPP Rev:F 06-04-28 Manufactured on Water Jet JLM  
IPP Rev:G As per Rev E 06-11-22 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063		Purchased	No			100	sf	245.3900	0.4722	1.988211			

**\*M2024T3S 063\***

\*\*

2024-T3 .063 sheet

5m 12-77

Location

Loc Qty

Loc Code

MAT022

245.39

119916

72.85

121197

172.54

119916

W/O:		WORK ORDER CHANGES					
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

DART AEROSPACE LTD		Work Order: 816357
Description: Angle		Part Number: D2175-1/-2
Inspection Dwg: D2175	Rev: E	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
12.650	+/-0.010	12.650"	✓		MT	11801
R0.35	+/-0.030	0.35"	✓		RG	
2.915	+/-0.010	2.916"	✓		✓	mm01
50°	+/-0.5°	50°	✓		Protractor	
0.300	+/-0.010	0.303"	✓		✓	mm01
1.050 Pitch	+/-0.010	1.051"	✓		✓	"
10.500	+/-0.010	10.501"	✓		✓	Protractor
11.550	+/-0.010	11.549"	✓		✓	"
0.550	+/-0.010	0.552"	✓		✓	mm01
0.900	+/-0.010	0.904"	✓		✓	"
0.063 thick	+/-0.010	0.063"	✓		✓	"
Grain Direction	N/A	✓	✓			✓
Ø0.128	+0.005/-0.001	0.129"	✓		✓	mm01
Ø0.172	+0.005/-0.001	0.174"	✓		✓	"

Measured by: JM	Audited by: S	Prototype Approval:	N/A
Date: 12-7-7	Date: 12/07/05	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue	KJ/JLM	
B	07.03.23	Dimensions revised per Dwg rev. E	KJ/JLM	

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

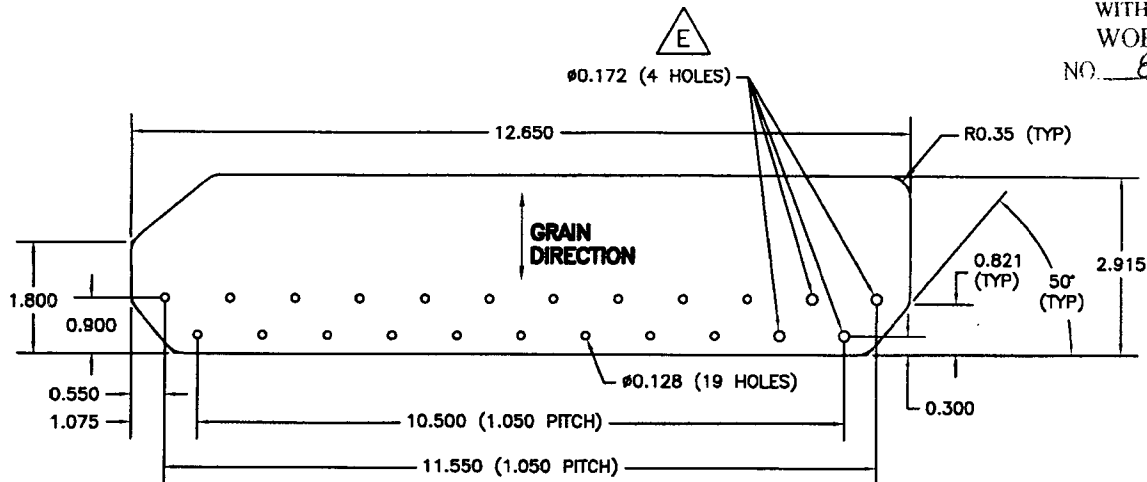
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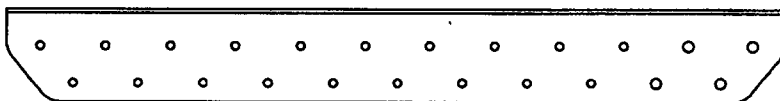


SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 86357

RELEASED  
2013  
12/06/28



**D2175-1F FLAT PATTERN**



**D2175-1 BEND DETAIL SHOWN  
(D2175-2 BENT OPPOSITE)**

**NOTES:**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK (REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) ALL DIMENSIONS ARE IN INCHES

DESIGN	RF	DRAWN BY	DATE	TITLE	DART AEROSPACE LTD HAMMERSBURT, ONTARIO, CANADA
CHECKED	PH	APPROVED	06.09.25	ANGLE	REV. E
DRAWING NO.	D2175				SHEET 1 OF 1
SCALE	1:3				
A	95.10.25	NEW ISSUE			
B	96.01.18	CHANGED DIMENSION			
C	00.09.11	UPDATE FINISH SPEC			
D	04.06.03	RE-DESIGN			
E	06.09.25	INC HOLE DIA TO Ø0.172, 4 HOLES			

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